

Work Order ID 52606

October 3, 2009 8:43:48 AM



ASAP

Page 1

Item ID: PB67-43001-219

Accept



Setup Start



Revision ID: C

Item Name: Angled Male Eye

Stop



Start Date: 10/05/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 0910-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.00" x 2.00" x 1.250" long

mf 09/10/07

11 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA543 and Dwg B67-43001
Identify as B67-43001-219
Dwg Rev C
Deburr

Folio Rev

H.A 09/10/07

B

10

1

PTO ->

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

H.A 09/10/07

10

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-219 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: / Date: 05-10-14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05-10-14

NCR: 52606		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/07	110	1 part scrap • 250" +0.000/-0.005 15" .240" R.C program error → modification in process	<u>/</u> RESUME	Fix Program by J.L.M. Scrap & no replace.	B.A 09/10/07	<u>/</u> 09/10/07	<u>/</u> RESUME	<u>/</u> 05-10-14

NOTE: Date & initial all entries

Work Order ID 52606

October 3, 2009 8:43:48 AM



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Item ID: PB67-43001-219

Accept



Setup Start



Revision ID: C

Stop



Item Name: Angled Male Eye

Start Date: 10/05/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>438</u>	0.00							
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Jul 09-10.08

(10)

9/10/8 *(10)* *SP*

09/10/13 *AG* *~~09/10/08~~* *AG*

PO 09-10-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 52606



Parent Item: PB67-43001-219RevB1



Parent Item Name: Angled Male Eye

Start Date: 10/05/2009

Required Date: 10/08/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	14.4229	1.0968			



6061-T6 Bar 2.00 x 2.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	14.42286316	
110167	0.532	
13085	12	
17124	1.89086316	

1.6968 *ml* 09/10/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

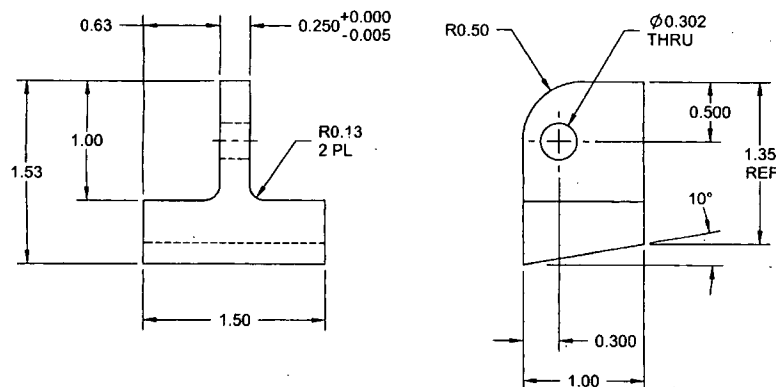
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NOTE: Date & initial all entries



B67-43001-219 ANGLED MALE EYE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 18 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-219 TITLE ANGLED MALE EYE	REV. C SHEET 1 OF 1 SCALE NTS	
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	09.02.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
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